

Work Order ID 69591

Thursday, May 12, 2011 3:22:31 PM



Page 1

Item ID: DSK078

Accept



Setup Start



Revision ID:

Stop



Item Name: D2893-1 TURNING DETAIL

Start Date: 5/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/25/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSK078

Rev A

100

0.00



MORI SEIKI CNC LATHE LARGE

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FA081
(4TH AXIS PLUG DT8492)

20 11.5.27

6

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

20 11.5.27

6

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

20 11/5/30

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

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Page 2

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Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

2Q 11.5-30



Packaging

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban ☐ Location: CNC

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/06/11

mf
11-06-02

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, May 12, 2011 3:22:38 PM

Page 1

Work Order ID: 69591



Parent Item: DSK078



Parent Item Name: D2893-1 TURNING DETAIL


Start Date: 5/12/2011

Required Date: 5/25/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-005  Round Billet, 17-4		Manufactured	No				Each	10.0000		6		2011-05-27	

Location

Loc Qty

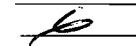
Loc Code

MAT043

10

68922 ✓

10



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD		Work Order:	69591
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.709	2.704	2.709	2.708	2.709
B	4.946	4.966		4.957	4.957	4.957	4.957	4.957
C	3.064	3.084		3.075	3.075	3.075	3.075	3.075
D	0.718	0.738		.725	.725	.725	.725	.725
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.934	2.954		2.945	2.945	2.945	2.945	2.945
G	2.166	2.186		2.175	2.175	2.175	2.175	2.175
H	3.890	3.910		3.900	3.900	3.900	3.900	3.900
I	0.914	0.934		.922	.922	.922	.922	.922
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.119	.119	.119	.119	.119
L								
M								
N								
O								
P								

Measured by: 29 Date: 11-5-27

Audited by: SA Date: 11/5/30

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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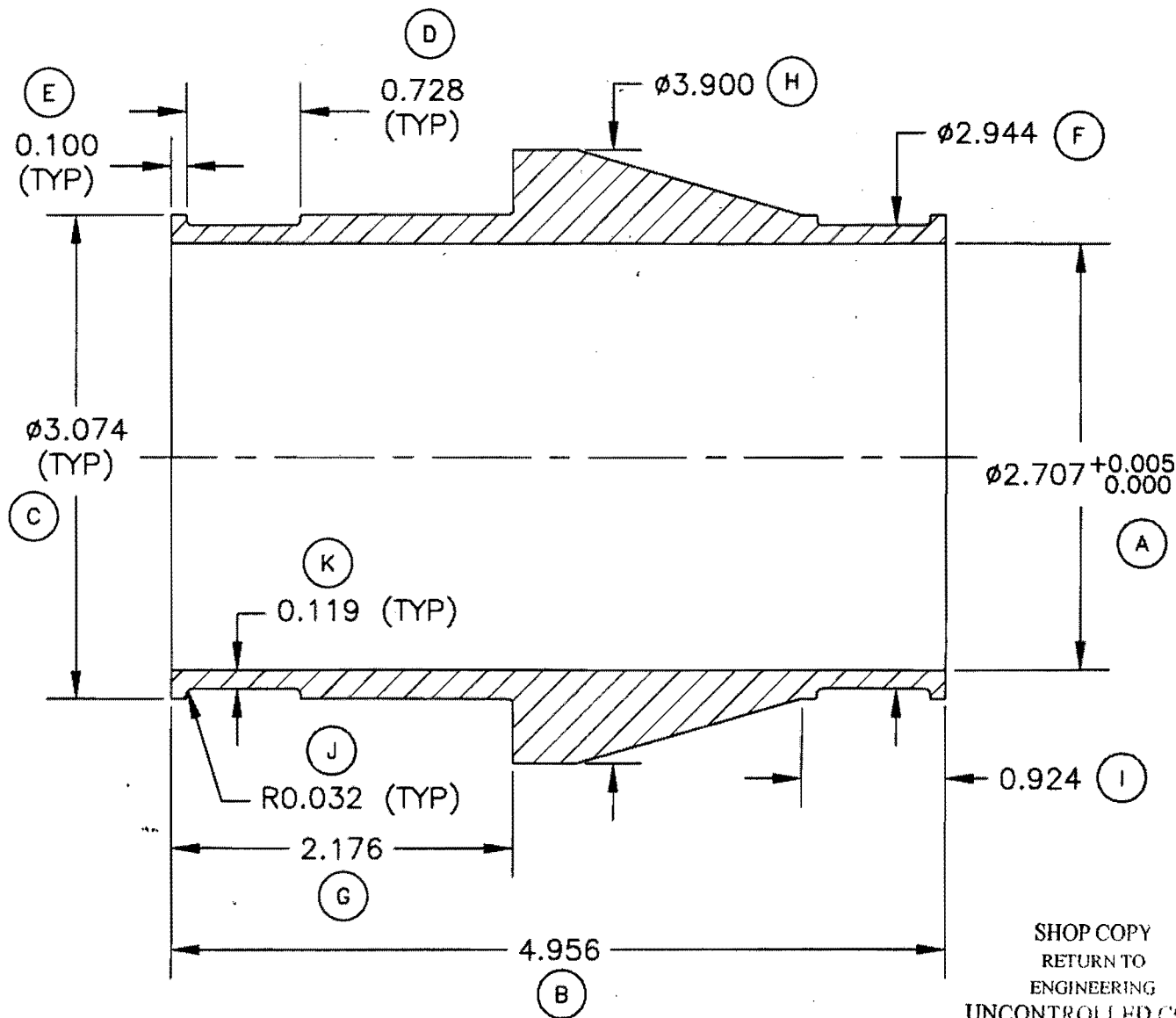
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DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



D2893-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69591

11-55-12

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